

Work Order ID 85125

June-04-12 8:20:50 AM

85125

Page 1

Item ID: D350-591-213

Accept

N900040100

Setup Start

NS1**Revision ID:****Item Name:** Heli-Access-Step, Short LH**Start Date:** 04/06/2012 **Start Qty:** 5.00 ***5*****Required Date:** 18/06/2012 **Req'd Qty:** 5.00 ***5*****Reference:****Approvals:** **Process Plan:** MLJ**Date:** 12/06/04 **Tooling:****Cust Item ID:****QC:****Date:****SPC (Y/N):****Customer:**

Run Start

NR1

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------------|----------------------------------|------------------------------|----------------|---------------|----------------------|-----------------------|-----------------------|--------------------------|------------------------|
|----------------------------------------|----------------------------------|------------------------------|----------------|---------------|----------------------|-----------------------|-----------------------|--------------------------|------------------------|

| | |
|-----------------|---------------------|
| Draw Nbr | Revision Nbr |
| D3078 | A |
| DSI 9472 | A |

100 0.00

100 DOCUMENT CONTROL

DC

Document Control

DAS
16
9-9
J B

J for MLJ 12-7-17
⑤

110 0.00

110 Large Fab

Large Fab

Large Fab

Memo 0.00

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

5 φ Ae
12-06-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 85125

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Item ID: D350-591-213

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Short LH

Stop

NS2

Start Date: 04/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

5/07/03

5

9

M
12.07.03

120

QC

Memo

0.00

Quality Control

130

Large Fab

0.00

5

9

M
12.07.03

130

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg

D3072

A/R Aluminum Rod 120834

3-Grind End Plate flush

M
12.07.04

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

5

9

M
12.07.11

140

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Short LH

Stop

NS2

Start Date: 04/06/2012 **Start Qty:** 5.00

5

Cust Item ID:

Required Date: 18/06/2012 **Req'd Qty:** 5.00

5

Customer:

Reference:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

150

QC5- Inspect part completeness to step on W/O

0.00

Sat 07/01

0.00

XS

4

150

QC

Memo

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

5

26 12-7-11

160

HandFinish

Memo

Hand Finishing

170

QC3- Inspect Part Finish

0.00

5

8 12-07-12

170

QC

Memo

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 85125

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Item ID: D350-591-213

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Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Short LH

Stop

NS2

Start Date: 04/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

200

Large Fab

Large Fab

0.00

(5)

Ø

Ae
12.07.12K
12.07.13

Ae 12.07.B

Memo
 1-Rivet Leg Assembly as per Dwg D3078.
 2-Bevel Aft end for welding
 3-Inspect for foreign object as per QSI 024
 4-Weld Aft End Plate as per QSI 004 & Dwg D3078
 A/R Aluminum Rod 120754
 5-Grind End Plate flush

210

QC10- Inspect visual per QSI004- ground welds

0.00

DAS
16
89

17/07/12

210

QC

Quality Control

220

QC5- Inspect part completeness to step on W/O

0.00

DAS
16
89

17/07/12

220

QC

Quality Control

X5
41

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2**Sequence ID/
Work Center ID**

230

230

HandFinish

Hand Finishing

**Operation
Description**

Chemical Conversion Coat per QSI005 4.1

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp*5X Ø LH 12/07/16*

240

240

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

*12'10" 3200°F
12'40"**5X Ø LH 12/07/16*

250

250

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch *121505* 0.00

0.00

Memo

5LH Ø 12/07/16

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 85125

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Item ID: D350-591-213

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012 **Start Qty:** 5.00 ***5***

Required Date: 18/06/2012 **Req'd Qty:** 5.00 ***5***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

260

QC3- Inspect Part Finish

0.00

260

QC

Quality Control

5 h+1 f M 11/02/16

270

Pick Kit

0.00

270

Packaging

Packaging

5


12/07/17 JG

280

QC4- 100% Inspect kits for completeness

0.00

280

QC

Quality Control

0.00

DAS
16
8.21(A).12

75

45

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 85125

June-04-12 8:20:50 AM

85125

Page 7

Item ID: D350-591-213

Accept

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012 Start Qty: 5.00 *5*

Required Date: 18/06/2012 Req'd Qty: 5.00 *5*

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

290

290

Packaging

Packaging

Operation
Description

Packaging

Memo

Identify and pack for shipping as per PPP D350-591-213
Location: _____
PPP Rev: _____

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

300

300

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

(50)

LFB/11/17 (C)

12/17/18 (J)

MF
12-07-18

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

June-04-12 8:20:55 AM

Page 1

Work Order ID: 85125

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125
D350-591-213

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DS19294 JLM
 IPP Rev:C 06-06-27 Revised as per DS19340 JLM IPP Rev:D
 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified
 by:JLM IPP Rev:E
 10.11.15 update qty on AN4-11A DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2622-120C | | Manufactured | No | | | 110 | Each | 156.6100 | 0.5 | 2.5 | ** | Ae 12-06-26 | |

D2622-120C

Step Extrusion

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| HALL | 16.37 | |
| 46910 | 2 | |
| 64409 | 6 | |
| 66970 | 7.7 | |
| 68293 | 0.25 | |
| 72131 | 0.42 | |
| WA | 130.88 | |
| 81507 | 4.88 | |
| <u>83894</u> | 126 | <u>2.5</u> |
| WA013 | 9.36 | |
| 75781 | 2 | |
| 77612 | 7.36 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 85125

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125
D350-591-213

Start Date: 04/06/2012

Start Qty: 5.00

Required Date: 18/06/2012

Required Qty: 5.00

D3067-1

Manufactured No

130

Each

172.0000

1

5

**

12.07.03

D3067-1

End Plate

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|----|-----|--|
| WA | 139 | |
|----|-----|--|

| | | |
|-------|---|--|
| 78608 | 4 | |
|-------|---|--|

| | | |
|-------|----|--|
| 83855 | 60 | |
|-------|----|--|

| | | |
|-------|----|--|
| 84534 | 75 | |
|-------|----|--|

| | | |
|-------|----|--|
| WA016 | 33 | |
|-------|----|--|

| | | |
|-------|---|--|
| 67582 | 2 | |
|-------|---|--|

| | | |
|-------|---|--|
| 68214 | 1 | |
|-------|---|--|

| | | |
|-------|---|--|
| 79607 | 1 | |
|-------|---|--|

| | | |
|-------|----|--|
| 83053 | 29 | |
|-------|----|--|

D3063-1

Manufactured No

130

Each

53.0000

1

5

**

12.07.03

D3063-1

Support

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|-------|----|--|
| WA016 | 53 | |
|-------|----|--|

| | | |
|-------|----|--|
| 71886 | 53 | |
|-------|----|--|

MS20600-AD4W4

Purchased No

180

Each

3,464.000

16

80

**

12.07.12

MS20600-AD4W4

Rivets

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|-----|------|--|
| 321 | 1000 | |
|-----|------|--|

| | | |
|--------|------|--|
| 121652 | 1000 | |
|--------|------|--|

| | | |
|-------|------|--|
| ST321 | 2324 | |
|-------|------|--|

| | | |
|--------|---|--|
| 121011 | 9 | |
|--------|---|--|

| | | |
|--------|-----|--|
| 121340 | 315 | |
|--------|-----|--|

| | | |
|--------|------|--|
| 121444 | 2000 | |
|--------|------|--|

| | | |
|-------|-----|--|
| WA018 | 140 | |
|-------|-----|--|

| | | |
|--------|-----|--|
| 118840 | 140 | |
|--------|-----|--|

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85125**Parent Item:** D350-591-213**Parent Item Name:** Heli-Access-Step. Short LH

85125
D350-591-213

Start Date: 04/06/2012**Required Date:** 18/06/2012**Start Qty:** 5.00**Required Qty:** 5.00

D3066-1

Manufactured No

180

Each

71.0000

2

10

**

D3066-1

Spacer

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST176 | 71 | |
| 83854 | 71 | |

D3065-041

Manufactured No

180

Each

13.0000

1

**

D3065-041

Step Leg Assembly Hi

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| WA | 13 | |
| 66149 | 0 | |
| 79336 | 1 | |
| 80880 | 12 | |

D3067-1

Manufactured No

200

Each

172.0000

1

5

**

D3067-1

End Plate

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| WA | 139 | |
| 78608 | 4 | |
| 83855 | 60 | |
| 84534 | 75 | |
| WA016 | 33 | |
| 67582 | 2 | |
| 68214 | 1 | |
| 79607 | 1 | |
| 83053 | 29 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

June-04-12 8:20:55 AM

Work Order ID: 85125

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125
D350-591-213

Start Date: 04/06/2012

Start Qty: 5.00

Required Date: 18/06/2012

Required Qty: 5.00

AN3-35A
AN3-35A
SJS
Bolt

Purchased No 270 Each 116.0000

2 10 ✓

**

JB

D2856-400
D2856-400
Abrasion Strip
SJS

Manufactured No 270 f 230.5445

0.6 3 ✓

**

JB

Location Loc Qty Loc Code

ST353 116
121652 116

12/6/12

ST403 216

81875 216

81875

ST409 14.5445

63735 0.6696

68076 0.3149

71164 8.46

79551 5.1

cut qty of 1 at 4.00" x 7.20" as per dwg (D2856-400-720)

AN4-11A
AN4-11A
SJS
Bolt

Purchased No 270 Each 296.0000

2 10 ✓

**

JB

12/07/11

Location Loc Qty Loc Code

ST356 296

118706 46

120731 100

121243 50

121708 100

121708

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

June-04-12 8:20:55 AM

Page 5

Work Order ID: 85125***85125***
D350-591-213**Parent Item:** D350-591-213**Parent Item Name:** Heli-Access-Step, Short LH**Start Date:** 04/06/2012**Required Date:** 18/06/2012

AN960JD416 NAS1149D0463J Purchased

No 270 Each 30 0000

12 60

**

121912 JB

AN960JD416

Washer

D2230-1

D2230-1

Lug

Manufactured

No 270 Each 20.0000

2

10 84135 JB

MS21042L3

MS21042L3

Nut

Purchased

No 270 Each 2,195.000

2

10 JB 120717

Location **Loc Qty** **Loc Code**

ST351 30 _____

116289 10 _____

119097 20 _____

Location **Loc Qty** **Loc Code**

ST480 20 _____

83273 20 _____

Location **Loc Qty** **Loc Code**

ST300 2195 _____

117885 32 _____

119017 952 _____

119075 138 _____

121349 221 _____

121444 852 121444

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

June-04-12 8:20:55 AM

Page 6

Work Order ID: 85125

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125
D350-591-213

Start Date: 04/06/2012

Start Qty: 5.00

Required Date: 18/06/2012

Required Qty: 5.00

AN4-13A

AN4-13A

Bolt

Purchased

No

270

Each

1,261.000

4

20

**

JB



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST357 | 1261 | |
| 119449 | 33 | |
| 120187 | 19 | |
| 120422 | 2 | |
| 120770 | 207 | |
| 121652 | 1000 | |

D2732

D2732

Rubber Extrusion

Manufactured

No

270

f

520.9153

1

5.263158

**

JB



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST410 | 520.915299 | |
| 70987 | 20.915299 | |
| 83560 | 500 | |

cutting of 4 at 1.00" as per dwg(D2732-030)

D2230-3

D2230-3

Manufactured

No

270

Each

90.0000

2

10

**

JB



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST480 | 90 | |
| 83261 | 90 | |

AN960JD10

NAS1149D0363J

Purchased

No

270

Each

0.0000

4

20

**

JB



| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Picklist Print

June-04-12 8:20:56 AM

Page 7

Work Order ID: 85125

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step. Short I H

MS21042L4

MS21042L4

S Nut
TB

Purchased

No

270

Each

3,910.000



30

**

Job

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00



AN4-16A
Bolt

Purchased

No

270

Each

169.0000



20

**

13X122416 Job

12/07/11

Location Loc Qty Loc Code

| | | |
|--------|------|--------|
| ST300 | 3910 | |
| 119075 | 116 | |
| 121011 | 537 | |
| 121444 | 2957 | 121444 |
| 121652 | 300 | |

Location Loc Qty Loc Code

| | | |
|--------|-----|--------|
| ST358 | 169 | |
| 120498 | 14 | |
| 121060 | 30 | |
| 121444 | 75 | 121444 |
| 121541 | 50 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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| | | D3078 | SHEET 1 OF 2 |
| DATE | 02.09.11 | TITLE | SCALE NTS STEP ASSEMBLY, HI SHORT |
| A | 02.09.11 | NEW ISSUE | |

RELEASED
02.01.10

| Part No. | Description | QTY -041 | QTY -042 |
|--------------|--------------------------------|-------------|-------------|
| D3078-041 | Step Assembly, High Short (LH) | X | |
| D3078-042 | Step Assembly, High Short (RH) | | X |
| D2622-60 | STEP EXTRUSION | 1 | 1 |
| D3063-1 | SUPPORT | 1 | 1 |
| D3065-041 | LEG ASSEMBLY | 1 | 1 |
| D3066-1 | SPACER | 2 | 2 |
| D3067-1 | END PLATE | 2 | 2 |
| MS20600AD4W4 | RIVET | 16 | 16 |
| | | | |

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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 WITHOUT NOTICE
 WORK ORDER
 NO. 100121-52158
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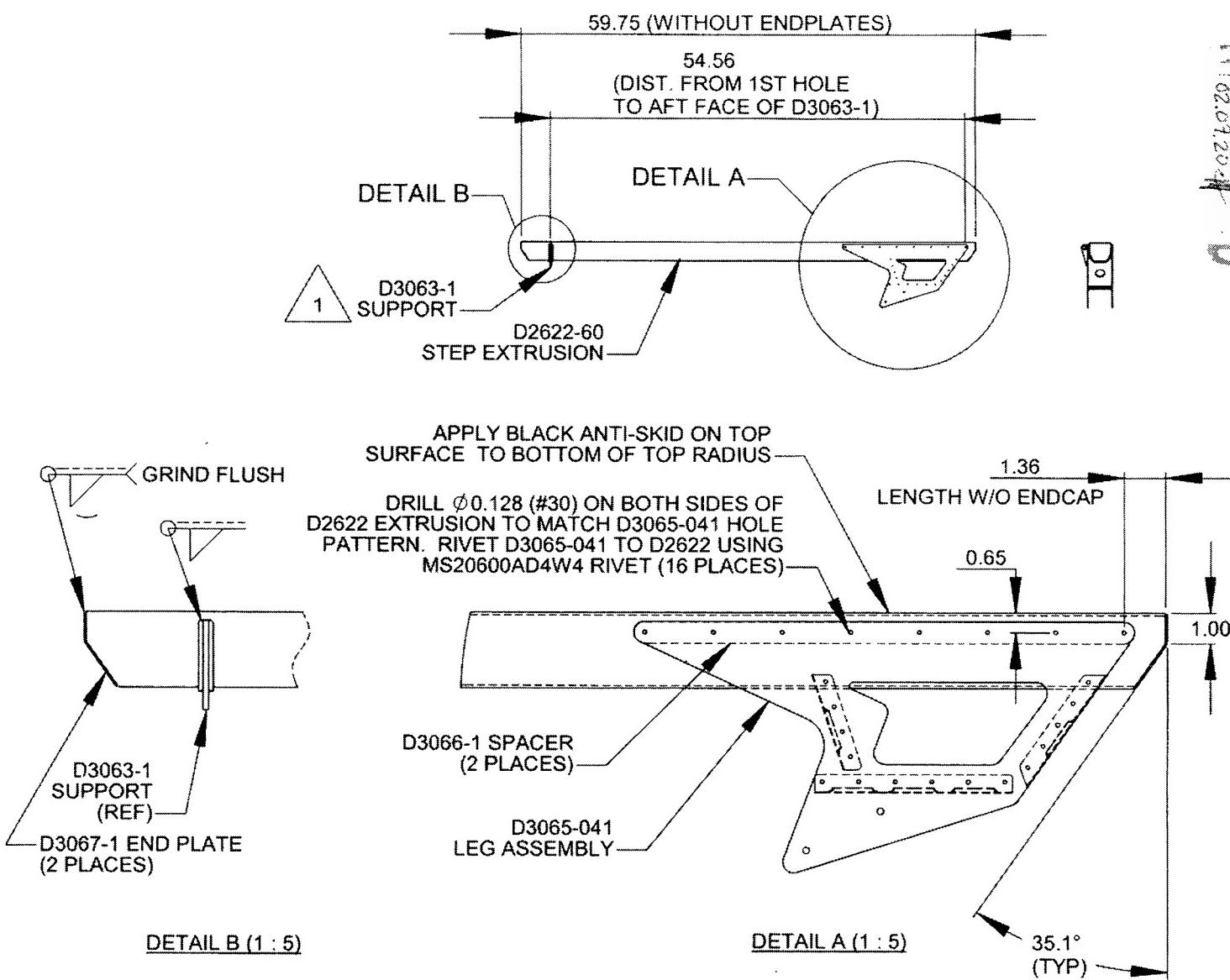
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| | | D3078 |
| DATE | 02.09.11 | TITLE |
| | | STEP ASSEMBLY, HI SHORT |
| | | SCALE 1:20 |
| | | REV. A |
| | | SHEET 2 OF 2 |

RELEASER
02.09.2004



DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

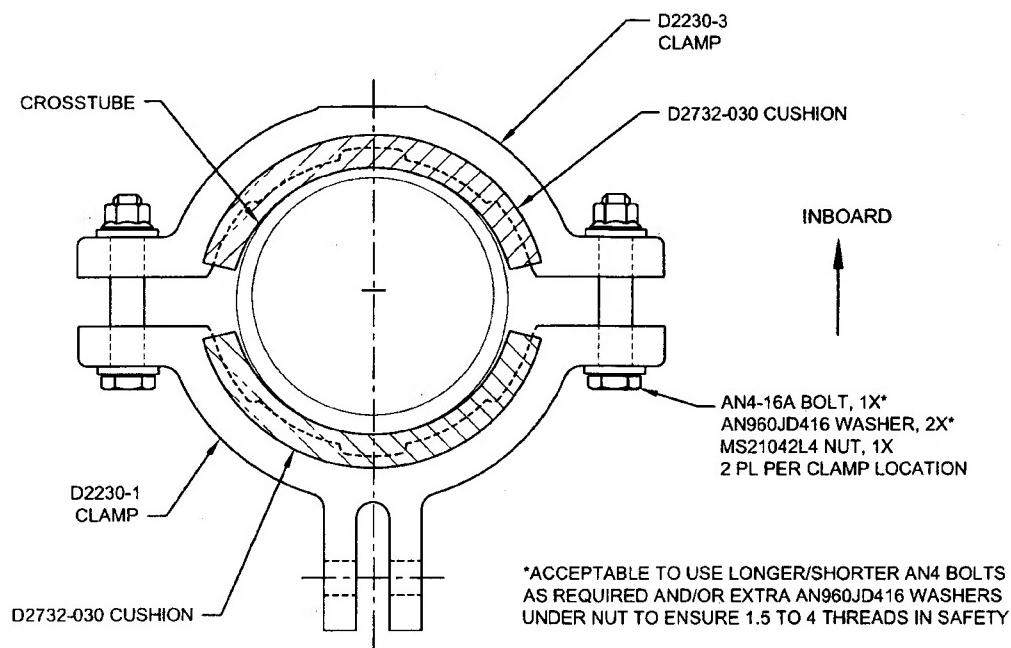
For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

| Qty -213 | Qty -214 | Qty -215 | Qty -216 | Part Number | Description |
|----------|----------|----------|----------|--------------|-------------------------------------------------------|
| X | | | | D350-591-213 | <i>Heli-Access-Step™</i> , Short Step – High Skid, LH |
| | X | | | D350-591-214 | <i>Heli-Access-Step™</i> , Short Step – High Skid, RH |
| | | X | | D350-591-215 | <i>Heli-Access-Step™</i> , Short Step – Low Skid, LH |
| | | | X | D350-591-216 | <i>Heli-Access-Step™</i> , Short Step – Low Skid, RH |
| 4 | 4 | 4 | 4 | AN4-16A | BOLT |

| | |
|-------------------------|-----------------------|
| CANADA | |
| DEPARTMENT OF TRANSPORT | |
| AIRCRAFT CERTIFICATION | |
| BRANCH | |
| DAO # 01-O-01 | |
| APPROVED | |
| BY: | D. SHEPHERD (DE # 02) |
| DATE: | 09.08.05 |
| CERT. NO.: | SH92-6 |
| ISSUE NO.: | 11 |

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**FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION**

2/28

| | |
|-------------------------|-----------------------|
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| BRANCH | |
| DAO # 01-O-01 | |
| APPROVED | |
| BY: | D. SHEPHERD (DE # 02) |
| DATE: | 09.08.05 |
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| Qty -211 | Qty -212 | Qty -213 | Qty -214 | Qty -215 | Qty -216 | Qty -311 | Qty -312 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|-----------------------------------------------|
| X | | | | | | | | D350-591-211 | Heli-Access-Step™, Long Step – High Skid, LH |
| | X | | | | | | | D350-591-212 | Heli-Access-Step™, Long Step – High Skid, RH |
| | | X | | | | | | D350-591-213 | Heli-Access-Step™, Short Step – High Skid, LH |
| | | | X | | | | | D350-591-214 | Heli-Access-Step™, Short Step – High Skid, RH |
| | | | | X | | | | D350-591-215 | Heli-Access-Step™, Short Step – Low Skid, LH |
| | | | | | X | | | D350-591-216 | Heli-Access-Step™, Short Step – Low Skid, RH |
| | | | | | | X | | D350-591-311 | Heli-Access-Step™, Long Step – High Skid, LH |
| | | | | | | | X | D350-591-312 | Heli-Access-Step™, Long Step – High Skid, RH |
| 1 | | | | | | | | D3070-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | 1 | | | | | | | D3070-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| | | 1 | | | | | | D3078-041 | STEP ASSEMBLY (HIGH-SHORT, LH) |
| | | | 1 | | | | | D3078-042 | STEP ASSEMBLY (HIGH-SHORT, RH) |
| | | | | 1 | | | | D3168-041 | STEP ASSEMBLY (LOW-SHORT, LH) |
| | | | | | 1 | | | D3168-042 | STEP ASSEMBLY (LOW-SHORT, RH) |
| | | | | | | 1 | | D3272-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | | | | | | | 1 | D3272-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| 4 | 4 | | | | | | | D2182B035 | RUBBER CUSHION |
| | | / 2 | 2 | 2 | -2 | | | D2230-1 | MOUNTING LUG |
| | | / 2 | -2 | -2 | 2 | 4 | 4 | D2230-3 | MOUNTING LUG |
| 8 | 8 | | | | | 2 | 2 | D2274 | RADIUS BLOCK |
| | | | | | | | | D2618 | BUSHING |
| 4 | 4 | / 4 | 4 | 4 | 4 | | | D2732-030 | CUSHION |
| 2 | 2 | / 1 | -1 | 1 | 1 | 2 | 2 | D2856-400-720 | ABRASION STRIP |
| 2 | 2 | | | | | | | D3064-1 | CLAMP |
| 1 | 1 | | | | | | | D3079-041 | SUPPORT ASSEMBLY |
| 4 | 4 | | | | | 2 | 2 | D3080-1 | CLAMP |
| | | | | | | | 1 | D3235-1 | MOUNTING LUG |
| | | | | | | | | D3278-041 | SUPPORT ASSEMBLY |
| 2 | 2 | / 2 | 2 | 2 | 2 | 2 | 2 | AN3-35A | BOLT |
| 10 | 10 | / 2 | 2 | 2 | 2 | | | AN4-11A | BOLT |
| | | / 4 | 4 | 4 | 4 | 8 | 8 | AN4-13A | BOLT |
| | | | | | | 2 | 2 | AN5-36A | BOLT |
| 4 | 4 | / 4 | 4 | 4 | 4 | 4 | 4 | AN960JD10 | WASHER |
| 20 | 20 | / 12 | 12 | 12 | 12 | 16 | 16 | AN960JD416 | WASHER |
| | | | | | | 4 | 4 | AN960JD516 | WASHER |
| 2 | 2 | / 2 | 2 | 2 | 2 | 2 | 2 | MS21042L3 | NUT |
| 10 | 10 | / 6 | 6 | 6 | 6 | 8 | 8 | MS21042L4 | NUT |
| | | | | | | 2 | 2 | MS21042L5 | NUT |
| | | | | | | | 1 | 1 | *DSI 9410-011 STEP MODIFICATION KIT |

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore NOT REQUIRED to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

| Qty -213 | Qty -214 | Qty -215 | Qty -216 | Part Number | Description |
|----------|----------|----------|----------|--------------|-------------------------------------------------------|
| X | | | | D350-591-213 | <i>Heli-Access-Step™</i> , Short Step – High Skid, LH |
| | X | | | D350-591-214 | <i>Heli-Access-Step™</i> , Short Step – High Skid, RH |
| | | X | | D350-591-215 | <i>Heli-Access-Step™</i> , Short Step – Low Skid, LH |
| | | | X | D350-591-216 | <i>Heli-Access-Step™</i> , Short Step – Low Skid, RH |
| 1 | 4 | 1 | 4 | AN4-16A | BOLT |

| |
|-------------------------|
| CANADA |
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| BY: <i>[Signature]</i> |
| D. SHEPHERD (DE # 02) |
| DATE: 09.08.05 |
| CERT. NO.: SH92-6 |
| ISSUE NO.: 11 |

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